

Work Order ID 143421

Tuesday, March 15, 2016 11:47:04 AM

143421

Page 1

Item ID: D5134-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Damper Support Assembly, LH
 Start Date: 4/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: MAR 17 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5134	B								

100

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK TO 5.125" LONG

*****CHECK GRAIN DIRECTION*****

0.00

0.00

16/04/24

DAS
08
9-89

110

110

HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and folio FB342

DWG REV: B
 FOLIO REV: 4A

DEBURR

0.04

0.12

DAS
14
9-89

16/04/26

DQA:

Date: 16/05/27



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ~~BA~~

Date: 16/05/20

Work Order update only ☐

Work Order: <u>143421</u> Part No. <u>D5134-041</u> NCR No. <u>16-5798</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																																																															
Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																																															
Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																																
Date: 16/05/02	Step #: 170	QTY Effective: 1	MRB (QS1042) Approval DAS 12 9-89 16/5/2																																																																																																																															
Description Work Order Deviation		Disposition																																																																																																																																
1 part the hole $\varnothing 0.500 \pm .000$ are $\varnothing 0.501$ R.C. reamer oversizing the hole.		Acceptable. To fit $\varnothing 0.501$ Bushing. Max ultimate load $\approx 3000^{13}$ (based on design development) which equates to ≈ 15 ksi.																																																																																																																																
		Completed By DAS 12 9-89 16/5/2 Lead hand / Supervisor Approval Verification DAS 14 9-89 16/05/02 QC / QA Coordinator Approval DAS 9 9-89 60502																																																																																																																																
Root Cause		FAULT CATEGORY																																																																																																																																
<table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☒</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>	Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☒	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td></tr> </table>	Pressure/Forced	☐	Temperature/Cure	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Damage/Defect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Marks/Chatter	☐	Drill Holes	☐	<table style="width:100%;"> <tr><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☒</td></tr> <tr><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>	Power Loss/Surge	☐	Positioned Wrong	☐	Folio/Program	☐	Outside Dimensions	☐	Grain	☐	Over/Under tolerance	☒	Weld	☐	Part Incorrect	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Out of Sequence	☐	Part Moved	☐	Off-set	☐	Drawing	☐	Mislabeled	☐	Finish	☐	Fit/Function	☐	Misread	☐	Misaligned/off center	☐	Turning Sequence	☐
Environment	☐	No Re-verification	☐																																																																																																																															
Design	☐	Operator	☐																																																																																																																															
Doc/Data	☐	Offset/Setup	☐																																																																																																																															
Equip/Tooling	☒	Supplier	☐																																																																																																																															
Handling/Pre	☐	Training	☐																																																																																																																															
Material	☐	Use for Testing	☐																																																																																																																															
Internal Transport	☐	Poor Information	☐																																																																																																																															
Tribal Knowledge	☐	Rushing	☐																																																																																																																															
LOA	☐	Product Improvement	☐																																																																																																																															
Substation	☐	Process Improvement	☐																																																																																																																															
Past Expiry Date	☐	Manufacturing Process	☐																																																																																																																															
Misidentified	☐	Past Due	☐																																																																																																																															
Pressure/Forced	☐	Temperature/Cure	☐																																																																																																																															
Bending	☐	Set-up	☐																																																																																																																															
Centre Not Concentric	☐	BOM/Route	☐																																																																																																																															
Cracks	☐	Broken/Damage/Defect	☐																																																																																																																															
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐																																																																																																																															
Cuffs	☐	Contamination	☐																																																																																																																															
Crushing	☐	Countersink	☐																																																																																																																															
Heat Treat	☐	Cut Too Short	☐																																																																																																																															
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐																																																																																																																															
Marks/Chatter	☐	Drill Holes	☐																																																																																																																															
Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																															
Folio/Program	☐	Outside Dimensions	☐																																																																																																																															
Grain	☐	Over/Under tolerance	☒																																																																																																																															
Weld	☐	Part Incorrect	☐																																																																																																																															
Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																															
Out of Sequence	☐	Part Moved	☐																																																																																																																															
Off-set	☐	Drawing	☐																																																																																																																															
Mislabeled	☐	Finish	☐																																																																																																																															
Fit/Function	☐	Misread	☐																																																																																																																															
Misaligned/off center	☐	Turning Sequence	☐																																																																																																																															
OTHER : ☐																																																																																																																																		

Work Order ID 143421

Tuesday, March 15, 2016 11:47:04 AM

143421

Page 2

Item ID: D5134-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Damper Support Assembly, LH

Start Date: 4/28/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DAS

16

04/26

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS

08

9-89

135

Chemical Conversion Coat per QS1005 4.1

0.00

135

HandFinish

Memo

0.01

Hand Finishing

DAS

16/05/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Tuesday, March 15, 2016 11:47:04 AM

Page 4

Stop ***NR2***

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.03

Memo

install bushings as per dwg

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Quality Control

Identify as per dwg & Stock Location: 0.00

0.00

0.00

Packaging

Packaging

Memo

LOCATION : LG054

DAG
6
9-83

MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 143421

Tuesday, March 15, 2016 11:47:04 AM

143421

Page 5

Item ID: D5134-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Damper Support Assembly, LH

Start Date: 4/28/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.01

Quality Control

MCS MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, March 15, 2016 11:47:03 AM

Page 1

Work Order ID: 143421

143421

Parent Item: D5134-041

D5134-041

Parent Item Name: Damper Support Assembly, LH

Start Date: 4/28/2016

Required Date: 5/6/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B3.000X4.00 0		Purchased	No				f	7.3296		2.696842			

M7075T73B3 000X4 000

7075-T73 Bar 3.0 x 4.0 grain direction along 3"

**

B.a 16/04/24

Location

Loc Qty

Loc Code

MAT

7.3296

→ m133512

5.6076

m133557

1.722

Each

17.0000

12

2.5875^{ft}

NAS77C6-021

Purchased

No

NAS77C6-021

BUSHING

**

134793X11 FF

MAY 17 2016

Location

Loc Qty

Loc Code

ST260

17

M133157

17

1

DQA: _____ Date: _____



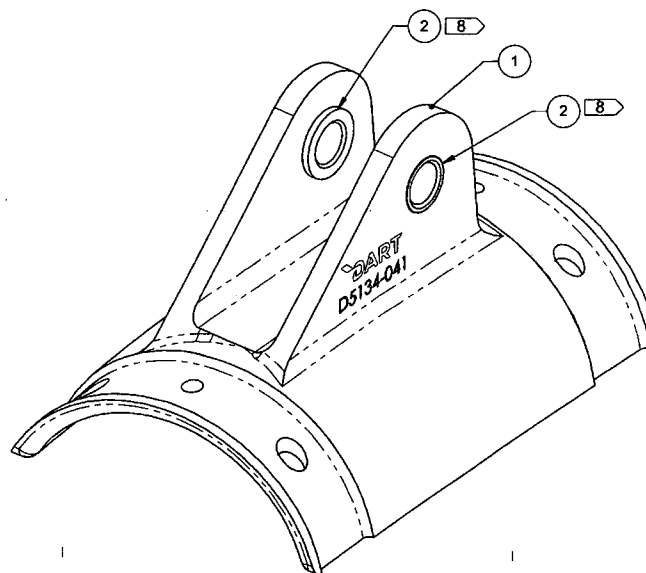
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

ITEM	QTY	P/N	DESCRIPTION
	X	D5134-041	DAMPER BRACKET ASSY, LH
1	1	D5134-1	DAMPER SUPPORT, LH
2	2	NAS77C6-021	BUSHING



D5134-041 DAMPER SUPPORT ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT WHITE PER DART QSI 005 4.2
MASK OFF INNER SURFACE OF BUSHING PRIOR TO APPLICATION OF PRIME/PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs
- 8) NAS77C6-021 BUSHINGS ARE PRESS FIT INTO D5134-1 DAMPER SUPPORT, IN ORIENTATION SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 143421 MJS
16-03-07

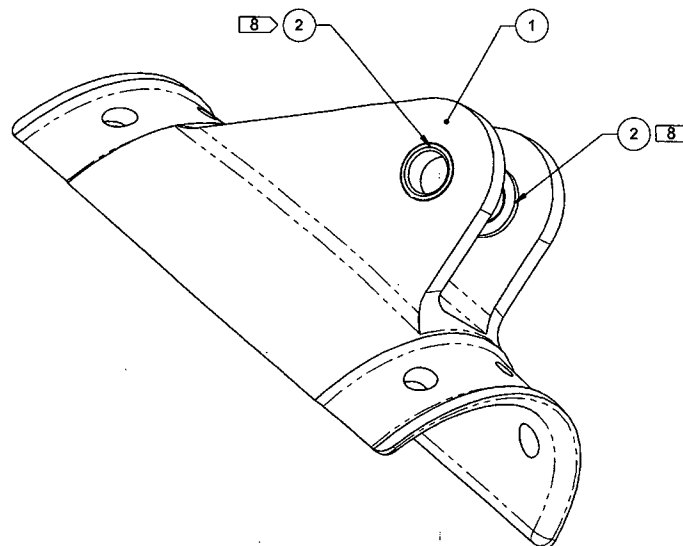
RELEASED

2015 MAY 12
A.R. Ecnis-SX

B	7075-T73 MATERIAL WAS 7075-T6, MINOR DIMENSIONAL CHANGES (SHT 3 & 4)	AP	15.04.24
A	NEW ISSUE	AP	14.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5134	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
DATE	15.04.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY -042	P/N	DESCRIPTION
	X	D5134-042	DAMPER SUPPORT ASSY, RH
1	1	D5134-2	DAMPER SUPPORT, RH
2	2	NAS77C6-021	BUSHING



D5134-042 DAMPER SUPPORT ASSY, RH

RELEASED

2015 MAY 12

A.R. ECR15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT WHITE PER DART QSI 005 4.2
MASK OFF INNER SURFACE OF BUSHING PRIOR TO APPLICATION OF PRIME/PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs
- 8) NAS77C6-021 BUSHINGS ARE PRESS FIT INTO D5134-2 DAMPER SUPPORT, IN ORIENTATION SHOWN

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5134	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
DATE	15.04.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

9 Ø0.188 TOOLING HOLE
AS REQUIRED, 2 PL

9 Ø0.257 TOOLING HOLE
AS REQUIRED, 4 PL

0.893
REF

0.36
TYP

R0.063
4 PL

DART
D5134-041

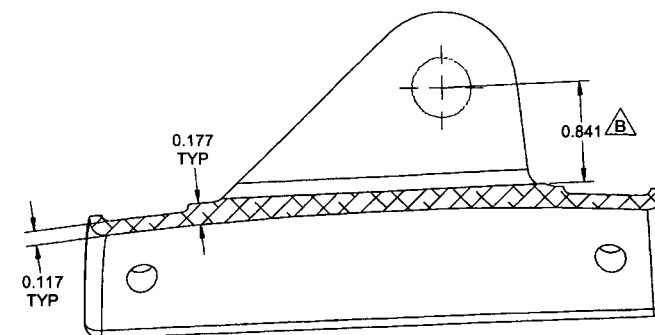
GRAIN
DIRECTION

4.671
REF

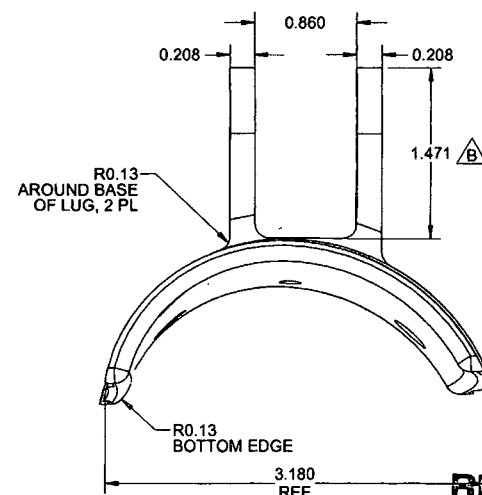
D5134-1 DAMPER SUPPORT, LH

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T73 (T7351 / T73510 / T73511) BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR
AMS-QQ-A-250/12 (AMS 4078), REF DART SPEC M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5134-041" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.38 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-1-REV.B.SLOPRT"
- 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES



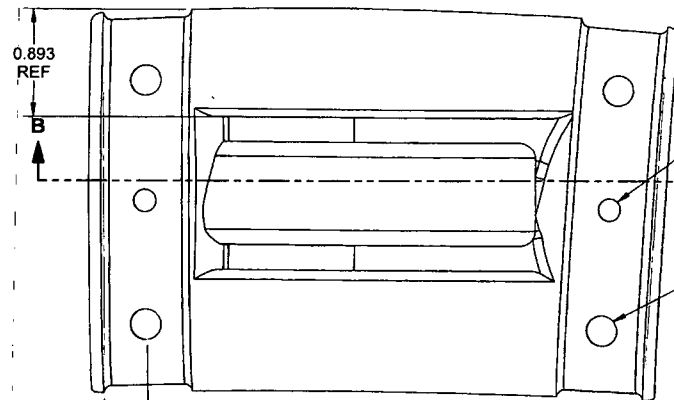
SECTION A-A



RELEASED

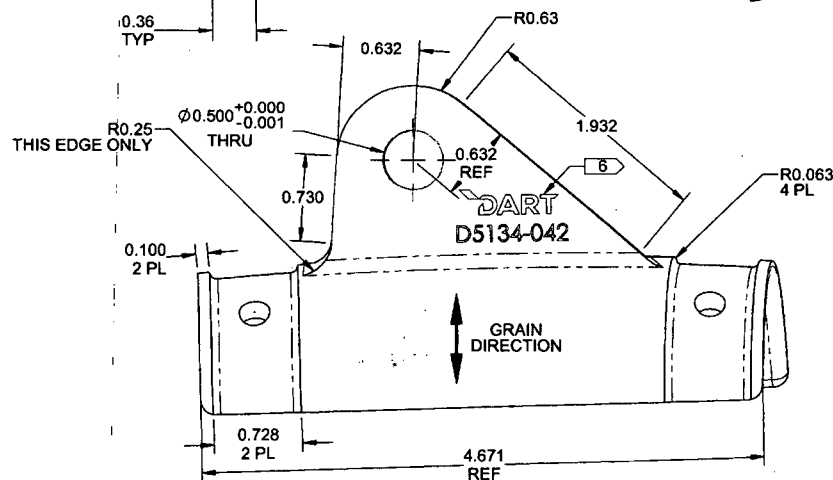
2015 MAY 12
A.R. ECMS-570

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	CP	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D5134	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
DATE		15.04.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Ø0.188 TOOLING HOLE
AS REQUIRED, 2PL

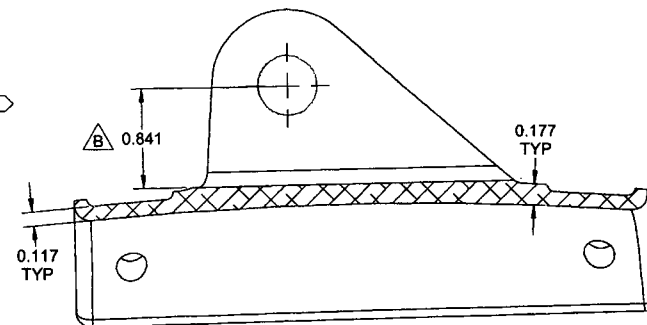
Ø0.257 TOOLING HOLE
AS REQUIRED, 4PL



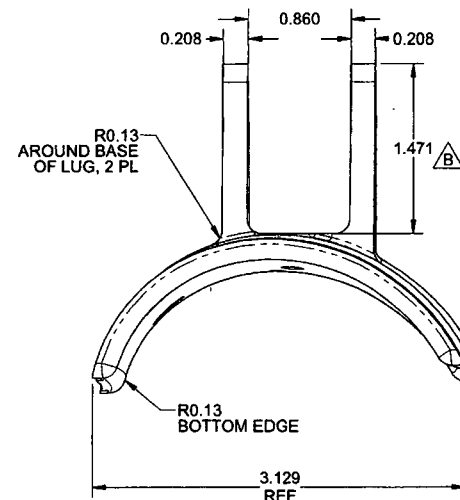
D5134-2 DAMPER SUPPORT, RH

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T73 (T7351 / T73510 / T73511) BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR
AMS-QQ-A-250/12 (AQMS 4078), REF DART SPEC M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5134-042" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.38 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-2-REV.B.SLDPRT"
- 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES



SECTION B-B



RELEASED

2015 MAY 12
A.R. EN 15-570

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	CP	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D5134	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
	DATE	15.04.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	